



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3414-3

Job Sheet 203869



Part No: D3414-3

Job Qty: 30 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Due Date: 12/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
105	HAAS 4 Axis	30 pcs	12/27/19	1.00	15.00		HAAS - 1	DTP 19-12-20
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
125	QC 8	30 pcs	12/27/19	0.00	0.00		QC 8 - 12	DAS 52 9-89 19/12/21
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	



Container No: S242825



Part: D3414 - 3
Job No: 203869
Serial No/Batch: S242825
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/20/19



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Date: 12/20/19

DAS
52
9-89

19/12/21

140 Packaging 3-1 - Stock - B4B	30 pcs	12/27/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	<i>a</i>
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	30 pcs	12/27/19	0.00	0.00	QC 21 - SA - 21	<i>DAS</i>
					QC 21 - SA - 70	<i>21</i>
					QC 21 - SA - 53	<i>3m</i>

Part Op 105 - Cut blanks: 2.50" x 0.500" x 2.250" long Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3 Dwg Rev
 Descriptions: _____ Folio Rev *AB*

125 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: *WAWL-5*)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B0.500X2.500	304 Bar .500 X 2.50	5.6250 ft (.1875 ea)	105-HAAS 4 Axis	<i>51829.59 x7</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-HAAS 4 Axis	M304B0.500X2.500	6	5	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug	0.510inches + 0.008 - 0.001	0.518 0.509	0.512"	
2	Lug	2.070inches ± 0.030	2.100 2.040	2.066"	
3	Lug	1.990inches ± 0.030	2.020 1.960	1.982"	
4	Lug	1.300inches ± 0.030	1.330 1.270	1.301"	
5	Lug	1.120inches ± 0.030	1.150 1.090	1.120"	
6	Lug	0.380inches ± 0.030	0.410 0.350	0.3725"	
7	Lug	0.060inches ± 0.010	0.070 0.050	0.067"	

Plex 11/28/19 9:18 AM Dart.lajeunesse.marie

DAS
73 19-12-19
9-89



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: